

SAIP July 2

Work Order ID 60051

Wednesday, June 23, 2010 4:06:33 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 6/23/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 11679

Pl 10.06.29

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Pl 10.06.29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Swlogbz

10

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

M 114 841

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: *2:00*

OVEN TEMPERATURE: *400°*

FINISH TIME: *2:30*

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

① Bl 10-6-29

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: B-A

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

EP 10/06/30 @

EP 10/06/30 @

10/06/30

MF 10-6-30

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Picklist Print

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Page 1

Work Order ID: 60051

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 6/23/2010

Required Date: 6/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	14.0000	1	1		Ppl 10.06.24	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			14						
				58122			2						
				59275			12						
D2221-5 Rib		Manufactured	No			100	Each	12.0000	2	2		Ppl 10.06.24	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			12						
				58027			4						
				59843			8						
D2221-7 Rib		Manufactured	No			100	Each	2.0000	1	1		Ppl 10.06.24	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			2						
				57805			2						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Page 2

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/23/2010

Required Date: 6/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3



Basket Hinge

Manufactured No

100

Each

4.0000

2

2



Pl 10.06.24

Location

Loc Qty

Loc Code

WA

4

57793

2

59264

2

100

Each

8.0000

2

2



(2)

Pl 10.06.24

D2235-1



Basket Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

8

59267

8

100

Each

35.0000

2

2



(2)

Pl 10.06.24

D2581



Mounting Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST

9

59121

9

WA

26

46086

2

51745

2

57185

1

59265

21

100

Each

16.0000

2

2



(2)

Pl 10.06.24

D3442-1



Shim

Manufactured No

Location

Loc Qty

Loc Code

WA

16

56579

4

58028

12

(2)

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Shop Packet Print

Page 2

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Page 3

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Parent Item Name: 350 Basket Base

Start Date: 6/23/2010

Required Date: 6/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

2.0000

2

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

2

58998

2

100

Each

8.0000

2

2

D3826-041

Manufactured No



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

8

58981

2

59730

6

100

Each

5.0000

1

D3827-041

Manufactured No



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

5

59276

5

100

Each

1.0000

1

D3832-1

Manufactured No



Mesh (Base)

Location

Loc Qty

Loc Code

WA

1

58165

1



Cpl 10.06.24

359844 → ②



Cpl 10.06.24



Cpl 10.06.24



Cpl 10.06.24

359341 → ①

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Page 4

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Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 6/23/2010

Required Date: 6/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

15.0000

2

2



Mesh (Base End Face)

Cpl 10-26-21

Location

Loc Qty

Loc Code

WA

15

56396

1

57834

2

59184

4

59902

8

(2)

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Shop Packet Print

Page 4

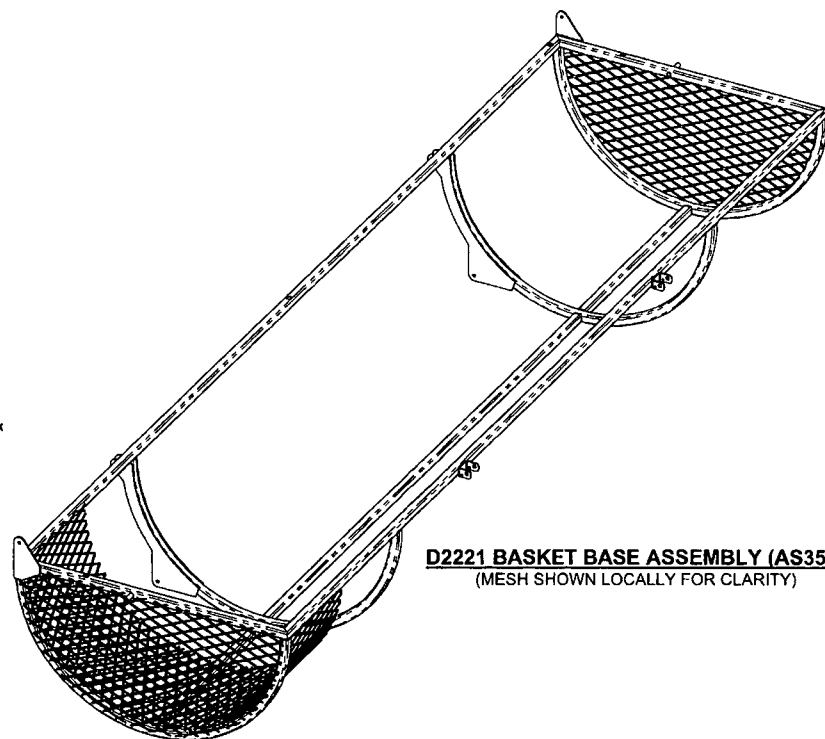
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A5-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.05.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

60051

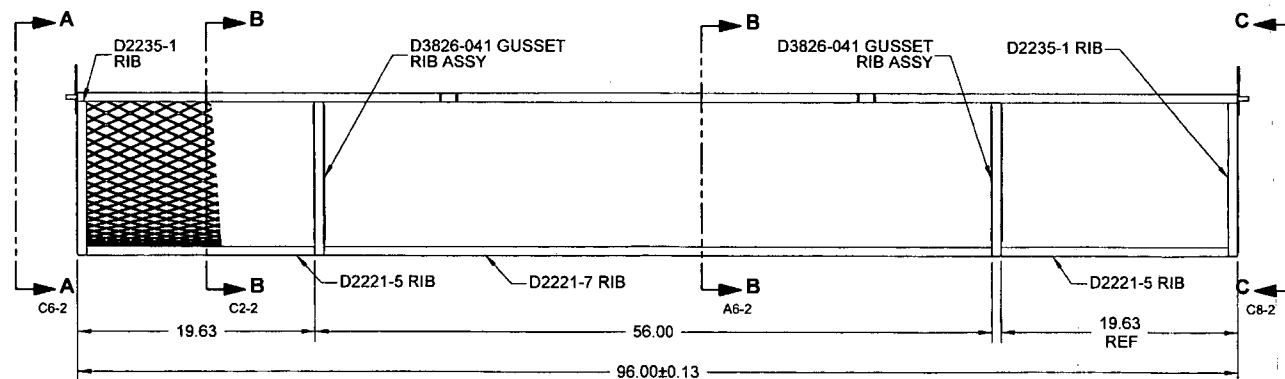
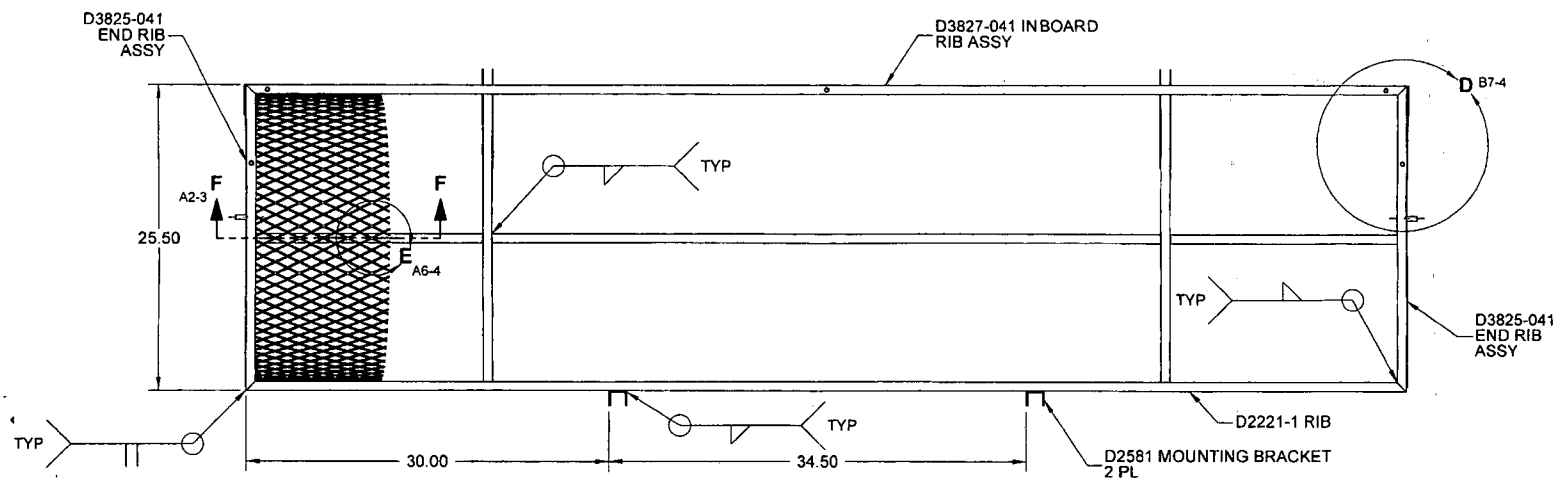
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NAD

60051

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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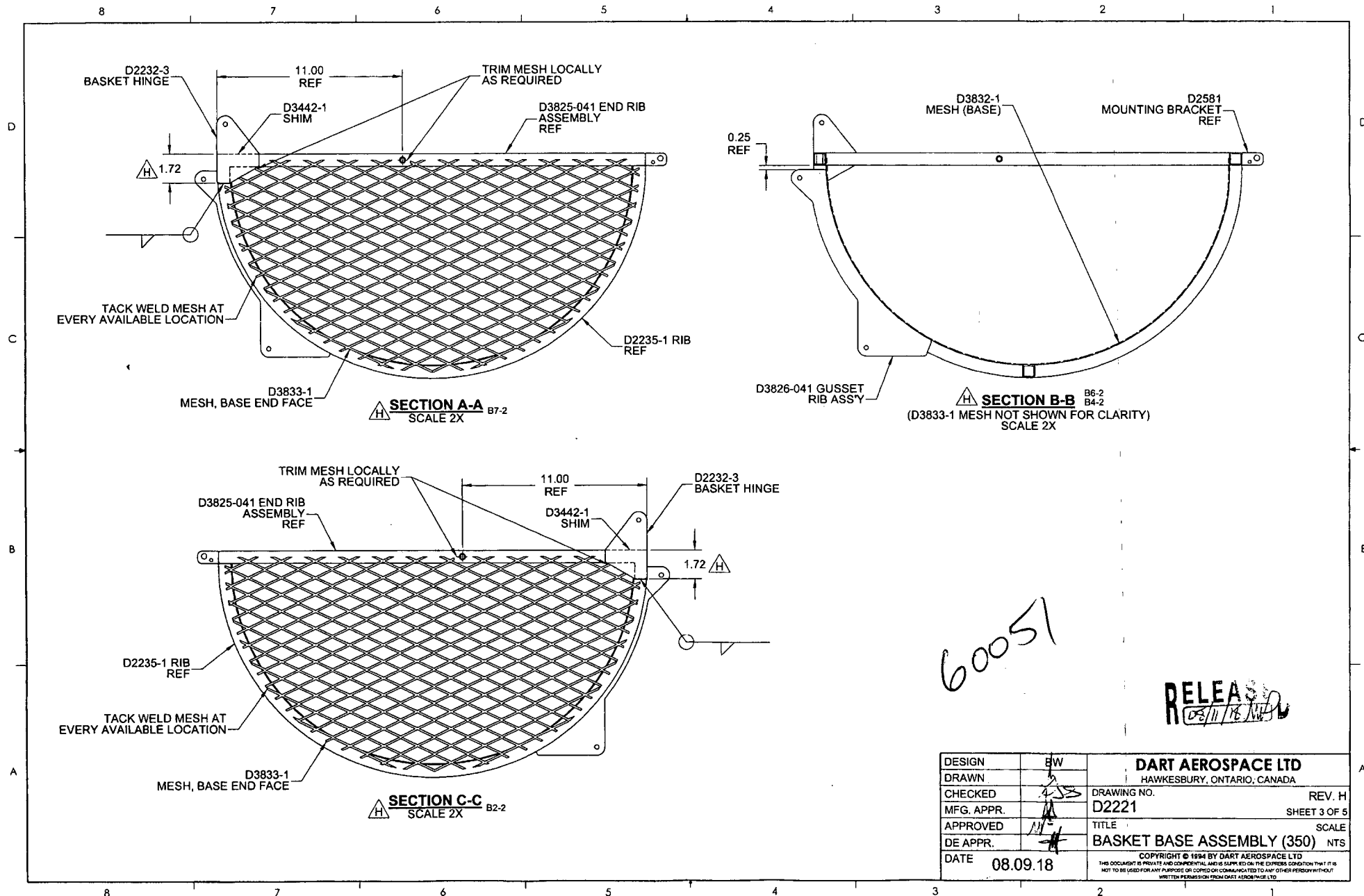
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60051

RELEASE

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	433	DRAWING NO.	REV. H
MFG. APPR.	11	D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	BASKET BASE ASSEMBLY (350)	NTS
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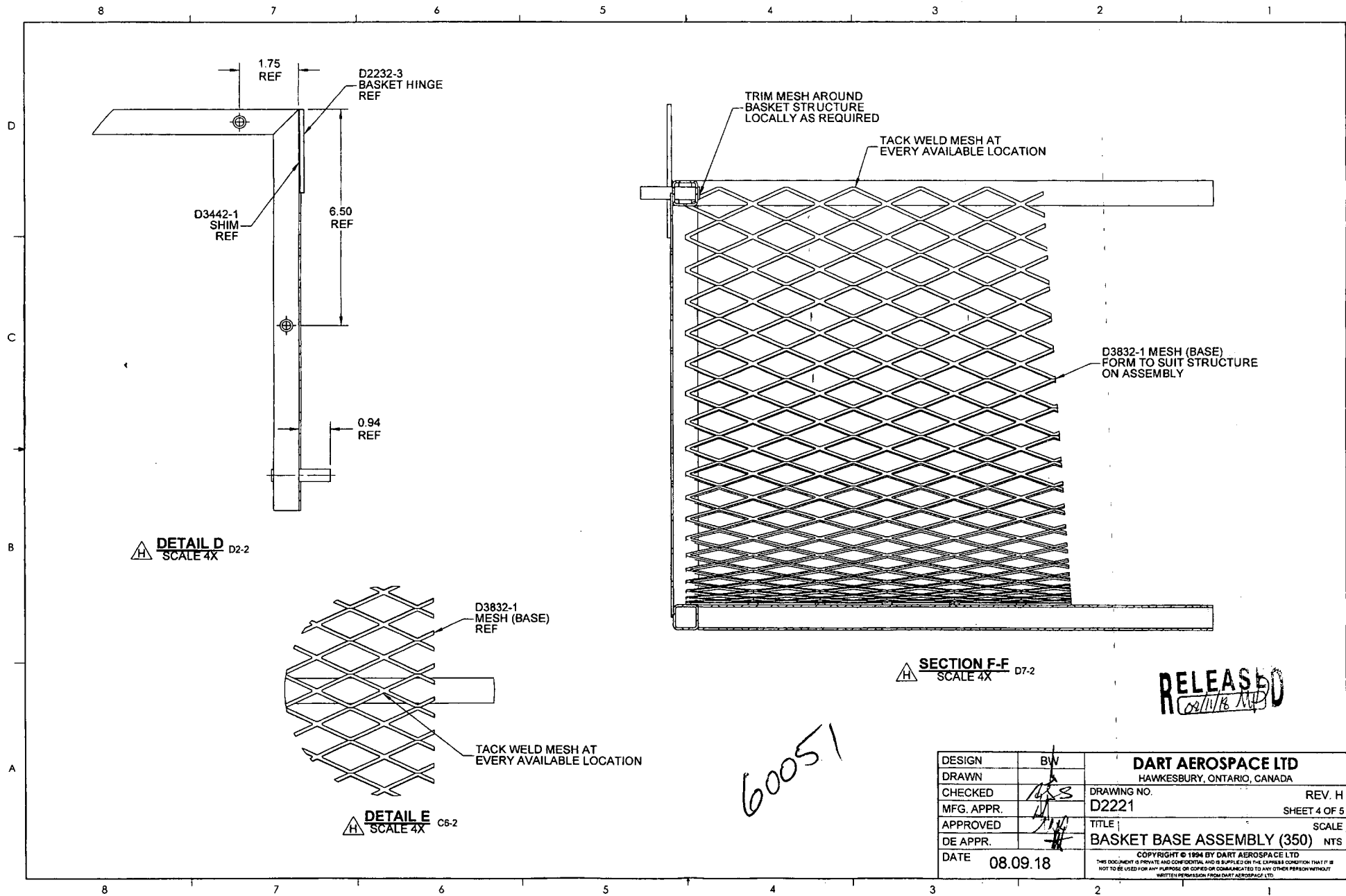
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RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2221 REV. H SHEET 4 OF 5 TITLE: BASKET BASE ASSEMBLY (350) SCALE: NTS DATE: 08.09.18 <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED	14/3		
MFG. APPR.	14/3		
DE APPR.	14/3		

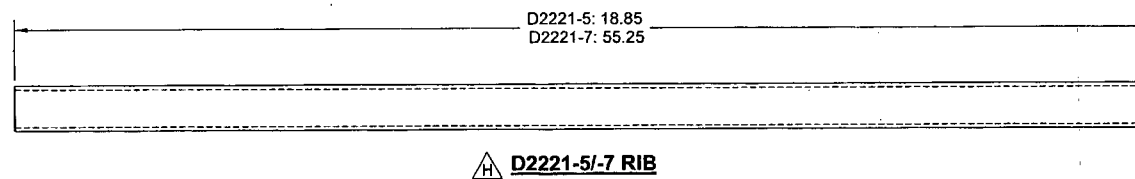
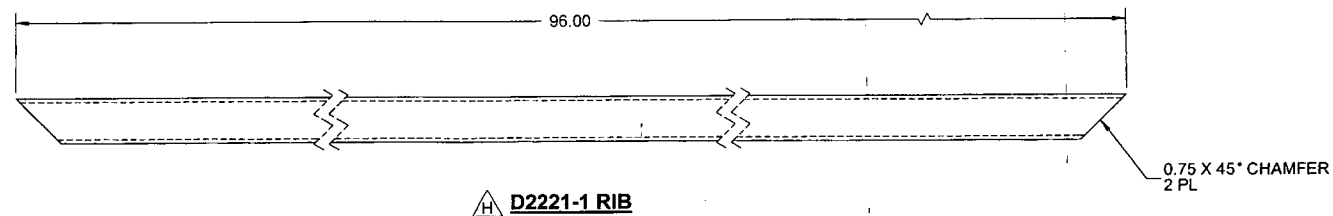
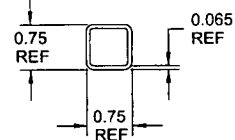
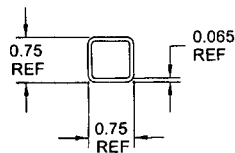
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	#	BASKET BASE ASSEMBLY (350)	NTS
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08/11/18

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